

Work Order ID 70597

Monday, June 13, 2011 10:56:43 AM



Page 1

Item ID: D412-666-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Gross Weight Towing

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-666	Rev C1								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP412-666-011		CHG 004	8.1.1.06/24					For CL 11-6-27
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									11/06/22
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control				8.1.1.06/24					40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-666-011 <input type="checkbox"/> Location: _____ <input type="checkbox"/> PPP Rev: _____ <i>R</i>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Rec'd 6/24 (2)**11/6/27 JG**ME
11-06-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 10:56:49 AM

Page 1

Work Order ID: 70597

Parent Item: D412-666-011

Parent Item Name: Gross Weight Towing

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B Added GHG 002 NG 02-03-06
IPP Rev:C As per Rev C JLM 07-09-07 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN6-15A Bolt		Purchased	No				Each	53.0000	16	16			
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Location	Loc Qty	Loc Code
ST342	53	
116191	3	
117795	50	

AN6-45A Bolt		Purchased	No				Each	23.0000	16	16			
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Location	Loc Qty	Loc Code
ST344	23	
115802	13	
117795	10	

AN960JD616 Washer	NAS1149D0663J	Purchased	No				Each	0.0000	32	32			
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D2888 Lug		Manufactured	No				Each	10.0000	8	8			
--------------	--	--------------	----	--	--	--	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST480	10	
69972	10	

69972

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 70597



Parent Item: D412-666-011



Parent Item Name: Gross Weight Towing

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L6

Purchased

No

Each

317.0000

16



Nut



Handwritten signature and date: 11/26/22

Location

Loc Qty

Loc Code

ST300

317

117343

117

117677

200

117343

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

REFERENCE ONLY

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/-45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

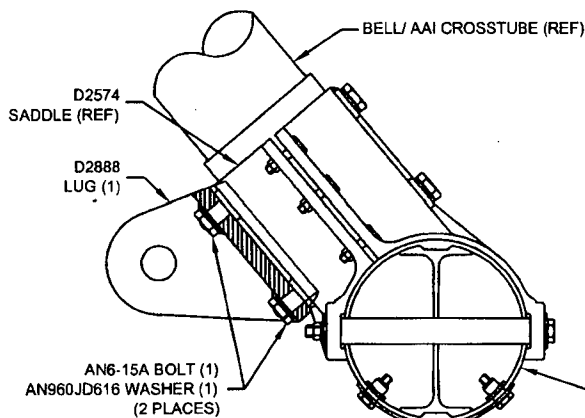


FIGURE 1
(BELL/AAI CROSSTUBES)

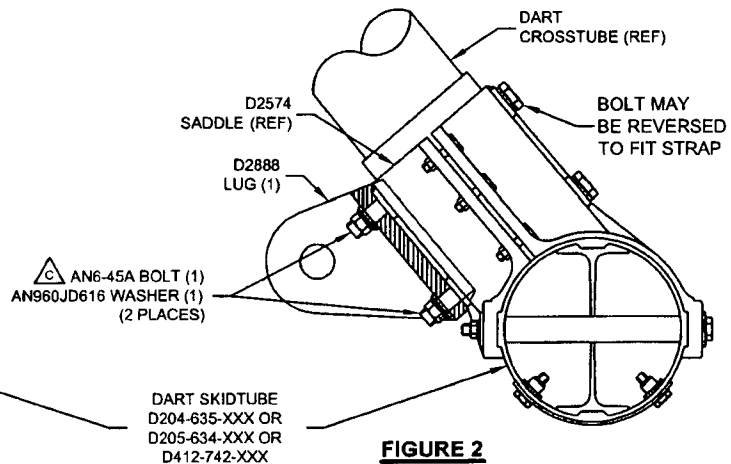


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-666	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		412 GROSS WEIGHT TOWING KIT	1:4
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